

PROCESS BULLETIN
DRYWALL ACCESSORY
PRODUCTS

K-SPRAY
CEILING TEXTURE
KSS

BULLETIN NO: J-4
DATE: (10/21/69)
PAGE: 1 of 4

APPROVALS:

JACKSONVILLE, SANTA
ANA, SEATTLE

CANCELS: NEW
DATE:

This specification covers manufacture of K-Spray Ceiling Texture using expanded polystyrene aggregate.

A. EQUIPMENT

1. Expanded Polystyrene

- a. Buccaneer Expander Model #BU 903
- b. Bin bags for storage
- c. Air conveyors and hoppers
- d. Bead Shredder
- e. Live bottom metering bin for aggregate

2. Dry Blending

- a. Bucket elevator (Universal Model #D 1500) with hopper inlet
- b. Ribbon Blender, 85 cu. ft. Hayes & Stoltz Catalog #285 with bottom receiving hopper
- c. St. Regis two-spout packer

B. RAW MATERIALS

1. Raw materials are as specified in Product Bulletins for K-Spray Ceiling Textures.
2. Refer to Process Bulletin J-1 for raw material testing.
3. Maintain less than 90°F storage temperature for raw polystyrene beads.
4. Protect casein and other natural adhesive binders from contamination and infestation by mold, bacteria, and rodents.

C. BATCHING

1. The raw materials, amounts, order of addition and specific mixing times are covered in appropriate Product Bulletins for K-Spray Ceiling Textures.
2. All raw materials are to be weighed accurately and even bag amounts checked prior to adding to ribbon blender.
3. Check discharge gates on ribbon blender. Gates must be in the closed position prior to adding materials to the blender.
4. Start ribbon blender and bucket elevator.

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C. BATCHING (cont.)

5. Set timer switch for proper amount of ground expanded polystyrene. Start screw feeder to add ground expanded polystyrene to the ribbon blender.
6. Add all dry materials through inlet hopper on bucket elevator.
7. Mixing time shall be as specified in Product Bulletin for K-Spray.
8. After complete mixing, transfer the batch to the filling hopper for bagging.

D. PACKING

1. Packer settings shall be adjusted to insure accurate minimum set weight in each bag.
2. Each batch shall be coded separately for identification using date, batch number, and appropriate formula code. Each container of each batch shall be coded.
3. One pound samples shall be taken from each batch as it is sacked, and sent to laboratory for testing.
4. No products shall be shipped until the batch samples have been tested and approved for shipment by the laboratory.
5. Products shall be warehoused so they can be shipped on a properly rotated basis according to production dates.

E. CLEAN-OUT

1. The entire mixing and packing system shall be cleaned when changing from casein to dry vinyl or other binder systems.
2. Before starting up on a new product, approximately 500 pounds of Whiting shall be run through entire system in order to fill all dead spaces.

F. RECORDS

1. Plant records shall be kept of date of raw material receiving, date of raw material use, date of manufacture and batch numbers of finished products, and date of product shipment.
2. The laboratory shall be notified of any equipment alterations or changes.

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PRE-EXPANDING POLYSTYRENE PROCEDURE:

A. FIRST STAGE EXPANSION

1. Fill pre-expander with expanded beads (for starting with empty expander after clean-out).
2. Start agitator and air conveyor under receiving hopper.
3. Select proper storage bin by opening proper gate valves. Open steam valve for first stage expansion. Allow 10-15 minutes for expander to heat up to operating temperatures.
4. Start bead feeder.
5. Fill bead feeder hopper and allow beads to flow into the feed auger.
6. Examine beads flowing from discharge and determine density after 10-15 minutes of operation. Density of first stage should range from 0.7 to 0.75 pounds per cubic foot. If beads are not in this range, adjust bead feeder and recheck density after 5 minutes operating at new setting.
7. Allow 18-20 hours ageing prior to second stage expansion.

B. SECOND STAGE EXPANSION

1. Start agitator and air conveyor under receiving hopper.
2. Open steam valves for first and second stage expansion.
3. Select proper bin from first stage expansion and fill small holding bin by drawing beads with the air conveyor attached to the storage bins.
4. Select proper storage bin to be filled from the air conveyor.
5. Open gate on holding bin allowing first stage beads to flow into the second stage venturi.
6. Examine beads flowing from the discharge and determine density after 5-10 minutes of operation. Density of second stage should range from 0.45 to 0.5 pounds per cubic foot.

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C. GRINDING

1. Select proper bin from second stage storage bins and transfer beads to small holding bin above the grinder.
2. Start grinder and blower and allow beads to flow into grinder from the holding bin.
3. Check sample for screen analysis at the start-up of each run.